

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010961**Date Inspected:** 01-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Fawen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder (OBG) Components**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

BAY 2

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW):

Weld joint # 006 located on Longitudinal Diaphragm LD3019 – 001. Welder is identified as 045209. ZPMC Quality Control (QC) Inspector is identified as Zhang Hai Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

Weld joint # 028 located on Longitudinal Diaphragm LD3021 – 001. Welder is identified as 045209. ZPMC Quality Control (QC) Inspector is identified as Zhang Hai Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

BAY 3

This QA Inspector observed the following work in progress:

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Flux Core Arc Welding (FCAW):

Weld joint # 014 located on Cross Beam CB202G – 014. Welder is identified as 206623. ZPMC Quality Control (QC) Inspector is identified as Yin Dong Hai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U5 – F.

Weld joint # 042 located on Cross Beam CB202G – 044. Welder is identified as 204338. ZPMC Quality Control (QC) Inspector is identified as Yin Dong Hai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2133.

Weld joint # 002 located on Cross Beam CB202G – 014. Welder is identified as 044790. ZPMC Quality Control (QC) Inspector is identified as Yin Dong Hai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U5 – F.

Weld joint # 038 located on Floor Beam FB205 – 041. Welder is identified as 204338. ZPMC Quality Control (QC) Inspector is identified as Yin Dong Hai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U5 – F.

BAY 5

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW):

Weld joint # 014 located on Traveler Rail 11TR2 – 018. Welder is identified as 217185. ZPMC Quality Control (QC) Inspector is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U5 – F.

Weld joint # 001 located on Bike Path BK001 – 050. Welder is identified as 067275. ZPMC Quality Control (QC) Inspector is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – Tc – U4c – F.

Weld joint # 001 located on Bike Path BK001 – 048. Welder is identified as 069895. ZPMC Quality Control (QC) Inspector is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – Tc – U4c – F.

Weld joint # 014 located on Traveler Rail 11TR1 – 006. Welder is identified as 250353. ZPMC Quality Control (QC) Inspector is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U5 – F.

Weld joint # 003 located on Bike Path BK001 – 049. Welder is identified as 204342. ZPMC Quality Control (QC) Inspector is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – Tc – U4c – F.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

No Relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang - 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Sandeep
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Quality Assurance Inspector

Reviewed By:	Hall,Steven
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QA Reviewer
